

Work Order ID 124283

September-11-14 12:01:04 PM

124283

Page 1

Item ID: D350-567-031

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Interior Window For -015 & -025

Stop

NS2

Start Date: 9/02/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 1409-16

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D350-567

E

5.0

MLJ 1501-08

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file and create labels per PPP D350-567-031 chg001

1x

DAS
46
8-29

JAN 09 2015

110

Packaging

0.00

110

Packaging

Memo

0.00

Packaging

Pick Packing Kit

1 JAN 07 2015

DAS
68
8-29

ENSURE DT 8439 TEMPLATE IS INCLUDED

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

1x

DAS
41
8-29

JAN 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124283

September-11-14 12:01:04 PM

124283

Page 2

Item ID: D350-567-031 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Interior Window For -015 & -025
 Start Date: 9/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D350-567-031 Location: _____ PPP Rev: _____	0.00 0.00	PPP 127621		DAS 66 9-89				JAN 09 2015
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MLJ 15-01-12 JMF 15-01-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling									
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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

September-11-14 12:01:03 PM

Page 1

Work Order ID: 124283

124283

Parent Item: D350-567-031

D350-567-031

Parent Item Name: Interior Window For -015 & -025

Start Date: 9/02/14

Required Date: 9/10/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-04-25 DD verified by: LL
IPP Rev:B 08-10-07 as per revD DD verified by:
13.10.15 AS PER IIN REV.E DD VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C632R12 *AN526C632R12* Screw		Purchased	No			120	Each	318.0000	8	8			DAS 06 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST328		318							
				m126474		100							
				m128403		218							
D2463 *D2463* 1/2" Seal (\$Per Foot)		Manufactured	No			120	f	903.5137	3.75	14			DAS 06 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST409		903.513684							
				110718		25.063684							
				115701		378.45							
				121929		500							
D3210-1 *D3210-1* Doubler For Interior Window -015 & -025		Manufactured	No			120	Each	12.0000	1	1			DAS 06 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST437		12							
				113671		4							
				116906		8							

JAN 08 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

September-11-14 12:01:03 PM

Page 2

Work Order ID: 124283

Parent Item: D350-567-031

Parent Item Name: Interior Window For -015 & -025

124283

D350-567-031

Start Date: 9/02/14

Required Date: 9/10/14

Start Qty: 1.00

Required Qty: 1.00

D3211-1

Manufactured No

120 Each

11.0000

1 1

DAS
05
9-09

D3211-1

DAS

Bracket For Interior Window For -015 & -025

46

Location

Loc Qty

Loc Code

ST437

11

105130

11

120 Each

29.0000

1 1

DAS
05
9-89

D3212-1

Manufactured No

120 Each

29.0000

1 1

DAS
05
9-89

D3212-1

DAS

Replacement Interior Window For -015 & -025

46

Location

Loc Qty

Loc Code

ST438

29

113221

11

113831

14

119657

4

120 Each

9.0000

1 1

DAS
05
9-89

D3213-041

Manufactured No

120 Each

9.0000

1 1

DAS
05
9-89

D3213-041

DAS

Replacement Interior Door For -015 & -025

46

Location

Loc Qty

Loc Code

ST438

9

106249

3

113802

4

115136

2

120 Each

2,465.000

40 40

DAS
05
9-89

MS20470AD4-5

Purchased

No

120 Each

2,465.000

40 40

DAS
05
9-89

MS20470AD4-5

DAS

RIVET, UNIVERSAL HEAD

46

C 29

Location

Loc Qty

Loc Code

ST312

2465

m128401

1653

m128813

812

JAN 08 2015

September-11-14 12:01:04 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

September-11-14 12:01:04 PM

Page 3

Work Order ID: 124283

Parent Item: D350-567-031

Parent Item Name: Interior Window For -015 & -025

124283

D350-567-031

Start Date: 9/02/14

Required Date: 9/10/14

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-6

Purchased

No

120

Each

4,106.000

90 90

MS20470AD4-6

RIVET

DAS

45

0-30

Location

Loc Qty

Loc Code

ST312

4106

118927

756

m128401

347

m128754

1488

m129499

1515

MS20470AD4-7

Purchased

No

120

Each

3,156.000

20 20

MS20470AD4-7

Rivet, Universal Head

DAS

43

0-30

Location

Loc Qty

Loc Code

ST312

3156

123525

1317

124231

539

m128228

1300

MS21042L06

Purchased

No

120

Each

392.0000

8 8

MS21042L06

Nut

DAS

43

0-30

Location

Loc Qty

Loc Code

ST307

392

m127304

3

m128976

189

m129499

200

DAS
06
9-89

DAS
06
9-89

DAS
06
9-89

JAN 0 8 2015

JAN 0 7 2015

DQA: _____ Date: _____



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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 124283

124283

Parent Item: D350-567-031

D350-567-031

Parent Item Name: Interior Window For -015 & -025

Start Date: 9/02/14

Required Date: 9/10/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN632J

Purchased

No

120

Each

409.0000

8

8

NAS1149DN632J DAS

Washer

46

9-80

**

Location

Loc Qty

Loc Code

CA

46

M129682

46

ST277

363

M126084

11

M127255

100

M128812

252

JAN 07 2015

DAS
86
9-89

mf

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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